

Split

Work Order ID 129454 -2

129454

Page 1

Item ID: D5152-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Post Mount Assembly

Start Date: 2/10/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 1502-10 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D5152

PA4

B

AA

110 Weld per dwg A/R S.S. rod Batch: 1123827 0.00

110

Large Fab

Memo

0.00

Large Fab

4 @ 15-2-27

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

① 15-2-02

DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

① 15-2-02

DAS
9
9-89

Work Order ID 129454

Tuesday, February 10, 2015 7:05:45 AM

129454

Page 2

Item ID: D5152-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Post Mount Assembly

Start Date: 2/10/2015 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

0.00

140

Spray Paint

Memo

0.00

Spray Painting

Prime as per dwg and QSI005 4.2

Batch: 130128

DAS
41
9-89

15-3-3

150

QC14- Inspect Spray Paint

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89

MAR 04 2015

160

Identify as per dwg & Stock Location 2654 0.00

160

Packaging

Memo

0.00

Packaging

4 MAR 04 2015

DAS
06
9-89

100

100

100

100

Work Order ID 129454

Tuesday, February 10, 2015 7:05:45 AM

129454

Page 3

Item ID: D5152-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Post Mount Assembly

Stop

NS2

Start Date: 2/10/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MCS 15-03-05
MF
15-3-41

Picklist Print

Tuesday, February 10, 2015 7:05:51 AM

Page 1

Work Order ID: 129454

129454

Parent Item: D5152-041

D5152-041

Parent Item Name: Fwd Post Mount Assembly

Start Date: 2/10/2015

Required Date: 2/10/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.01.09 NEW ISSUE DD VEREJLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5152-1		Manufactured	No				Each	0.0000		4			
D5152-1									**				
Fwd Post Mount													
D5152-5		Manufactured	No				Each	0.0000		4			
D5152-5									**				
Fwd Step Post													

129633 x6

129631 x6

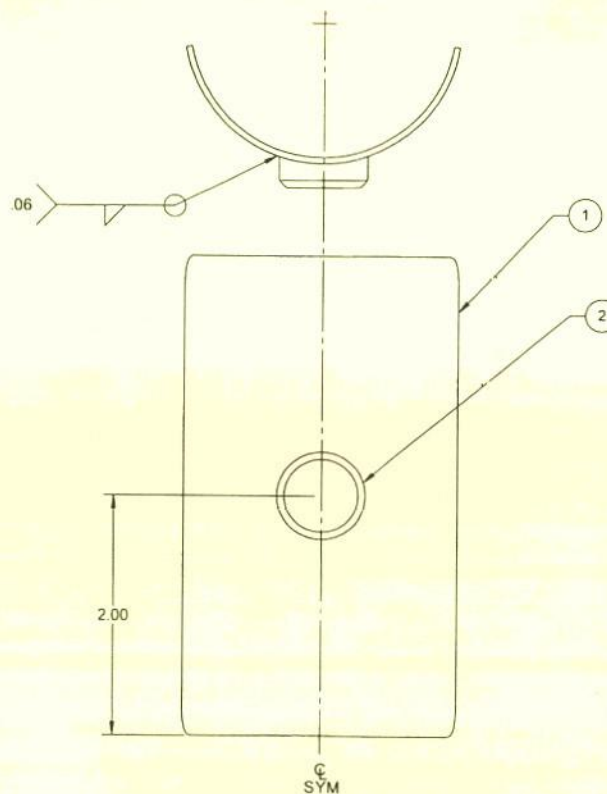
**

EL 15-2-27

**

EL 15-2-27

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5152-041	FWD POST MOUNT ASSY
1	1	D5152-1	FWD POST MOUNT
2	1	D5152-5	FWD STEP POST



D5152-041 FWD POST MOUNT ASSEMBLY

129454 MLC
15-02-10

RELEASED

2015 FEB 09

ECN 15-516 9

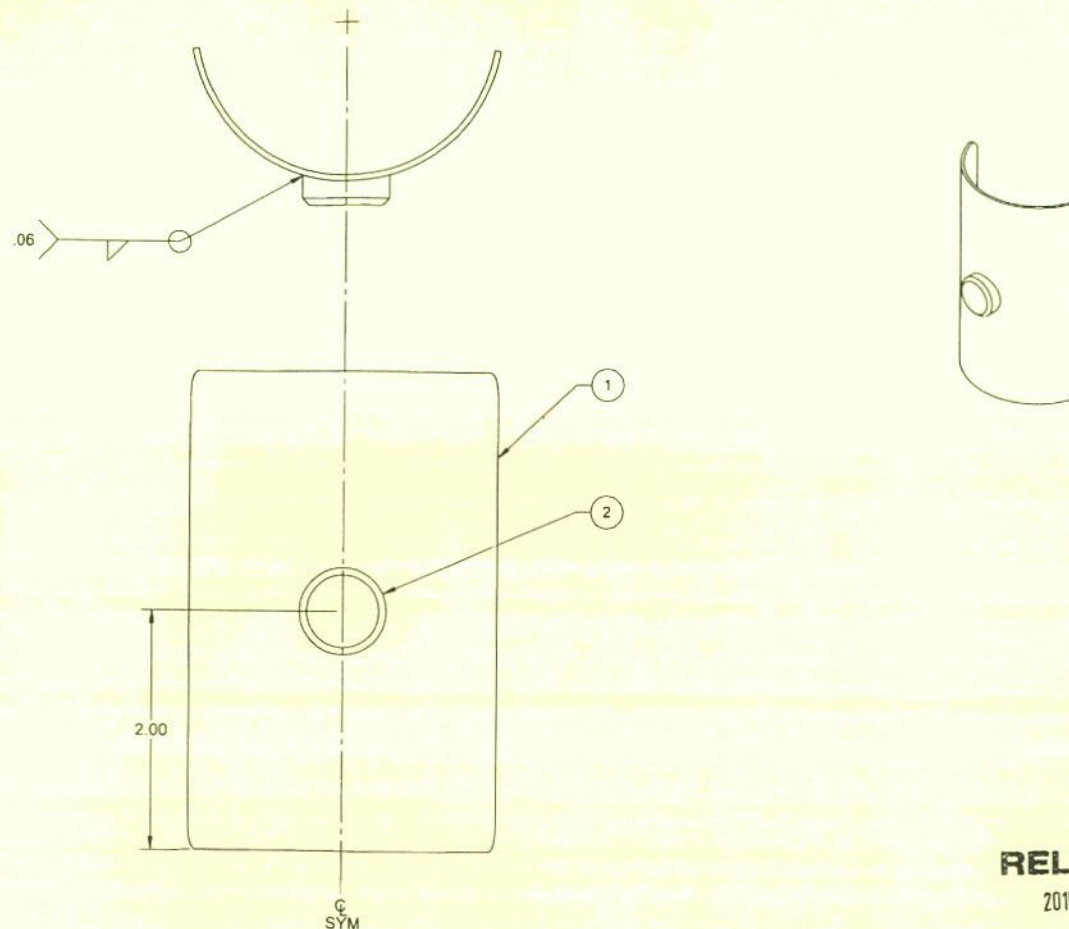
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-041= 0.21 lbs

B	COMPLETE REDESIGN, SEE PREVIOUS REV FOR DETAILS	DB	15.01.09
A	NEW ISSUE	DB	14.09.03
REV	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5152-043	AFT POST MOUNT ASSY
1	1	D5152-3	AFT POST MOUNT
2	1	D5152-7	AFT STEP POST



D5152-043 AFT POST MOUNT ASSEMBLY

RELEASED

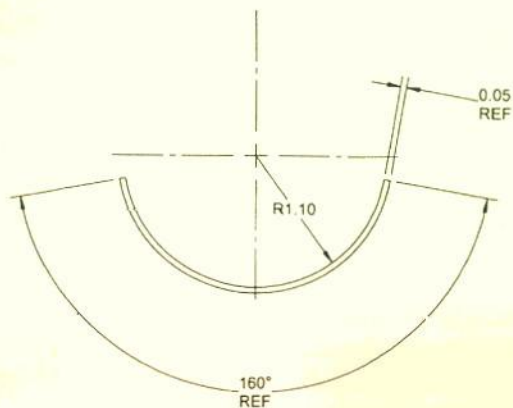
2015 FEB 09

NOTES:

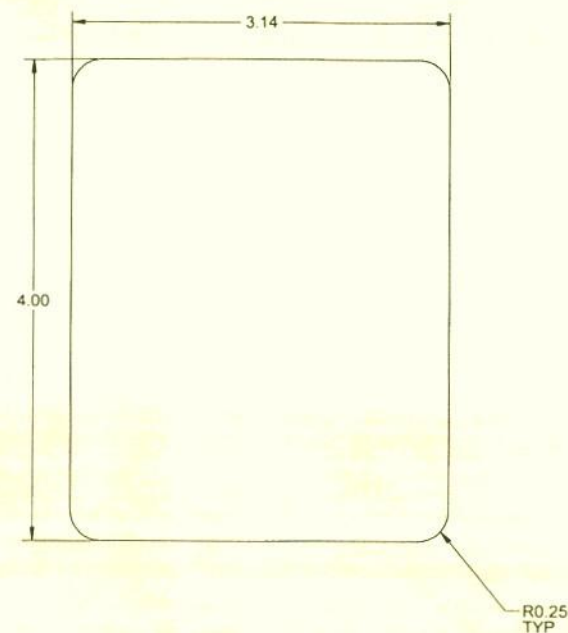
- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-043= 0.23 lbs

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D5152-1 FWD POST MOUNT
(MAKE FROM D5152-1F)



D5152-1F FWD POST MOUNT
(FLAT PATTERN)

RELEASED

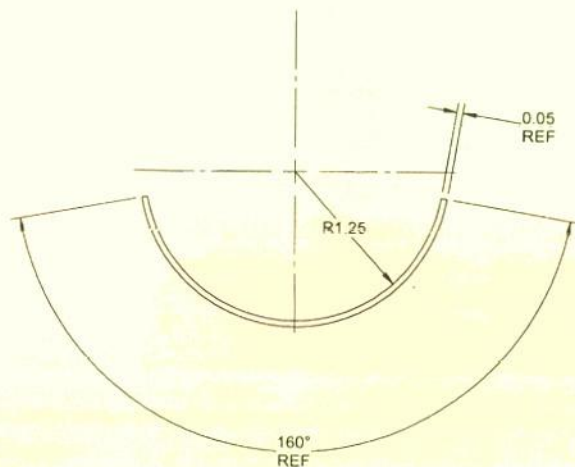
2015 FEB 09

NOTES:

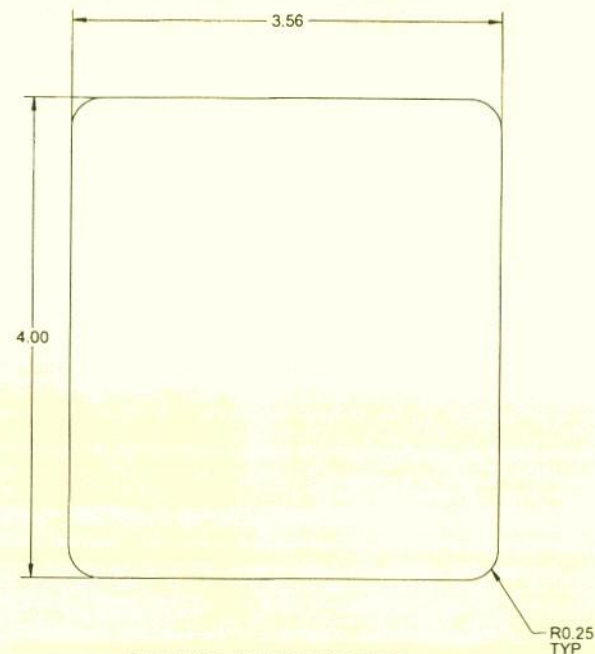
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR	DD	D5152	SHEET 3 OF 5
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DE APPR	DS	POST MOUNT	NTS
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D5152-3 AFT POST MOUNT
(MAKE FROM D5152-3F)



D5152-3F AFT POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

R1.150

R1.300

0.20

0.20

0.06 X 45° CMF

0.06 X 45° CMF

Ø0.725

Ø0.725

D5152-5 FWD STEP POST

D5152-7 AFT STEP POST

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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8 7 6 5 4 3 2 1

